

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006800**Date Inspected:** 03-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Luan Zhae Gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Superstructure Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Rory O'Kane was present during the times noted above for observations relative to the work being performed.

Outside Assembly Area

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of the Complete Joint Penetration (CJP) splice welds on segment assemblies designated as 4AW to 4BW. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedures as follows:

1. Monitoring of welding parameters in accordance with the applicable Welding Procedure Specification
2. Monitoring of welding personnel qualifications in accordance with the applicable Welding Procedure Specification as follows:

Welders Name: Li Guimin

Welder ID # 220069

Process Qualified: FCAW

Position Qualified: 3G

Issue Date: 03-20-2009

Welders Name: Liu Haung

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Welder ID # 218958
Process Qualified: FCAW
Position Qualified: 3G
Expiration Date: 03-09-2012

This QA Inspector reviewed the contract files and tracking logs for the Magnetic Particle Testing (MT), Ultrasonic Testing (UT), Welding Procedure Specifications (WPS), Procedure Qualification Records (PQR), and QC Inspector records to this date.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, who represents the Office of Structural Materials for your project.

Inspected By:	O'Kane,Rory	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
